

Work Order ID 55470

January 19, 2010 12:41:14 PM



Page 1

Item ID: D3774-1

Accept



Setup Start



Revision ID:

Item Name: Seat Bottom, LH/RH

Stop



Start Date: 1/19/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/22/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 10-1-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

D3774

Rev B

100



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-1 Set up clamping frame as per folio

BB
10/01/19

110



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

To in Back of
Page #3.

BB
10/01/19

X4
X3

120



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3774-1 and Folio Dwg. Rev.
 Folio Rev.

BB
10/01/14

X4
X3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55470

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Page 2

Item ID: D3774-1

Revision ID:

Item Name: Seat Bottom, LH/RH

Start Date: 1/19/2010 Start Qty: 5.00

Accept



Setup Start



Required Date: 1/22/2010 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

BB
10/01/19
X4
X3

140



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

Trim to Finished Dimensions

BB
10/01/19

R.D.V.X

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1) Check dimensions to ensure conformity to drawing tolerances.

BB
10/10/20

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/19		CORNER CRACKED.						

NOTE: Date & initial all entries

Work Order ID 55470

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Page 3

Item ID: D3774-1

Accept



Setup Start



Revision ID:

Item Name: Seat Bottom, LH/RH

Stop



Start Date: 1/19/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/22/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: G A

0.00

2) Solutio

+3

0.00

83 10/01/20

③

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/20 JJ

MF 10-1-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3774-1 CDR 10-001
 PAR #: _____ Fault Category: Thermal fatigue NCR: Yes No DQA: W Date: 10.01.21
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: F Date: 10/01/26

NCR: 55470		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/20	#100	Qty +4 off out of 7 parts Scrap 2 c corners keep cracking	<u>W</u>	- Scrap Qty +4 parts that have the corners cracked. no replace.	<u>BB</u> 10/01/20	<u>S</u> 10/01/20	<u>W</u> per BB per 10/01/20	<u>S</u> 10/01/20
			<u>per DSE</u> <u>DSE</u>	- Problem is not solved. open CDR for either a Design change or Repair scheme	<u>H</u> 10.01.21			<u>S</u> 10/01/20

NOTE: Date & initial all entries

Picklist Print

January 19, 2010 12:41:13 PM

Page 1

Work Order ID: 55470



Parent Item: D3774-1



Parent Item Name: Seat Bottom, LH/RH

Start Date: 1/19/2010

Required Date: 1/22/2010

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD

Start Qty: 5.00

Required Qty: 5.00

IPP REV. B Dwg. Update 08.08.19 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin No	Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04						110	sf	956.3961	53.3350			

GE PLASTICS LEXAN SHEET

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	956.396098	
103106	1.6765	
105330	47.8767	
109455	40.5717	
111710	329.893632	
112585	536.377566	

BB 10/01/20
X 7

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55470
Description: Seat Bottom	Part Number:	D3774-1
Inspection Dwg: D3774 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: RB

Date: 10/01/20

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.371	✓			
33.9	+/-0.100	33.8	✓			
17.4	+/-0.100	17.375	✓			
0.085	Min	.088	✓			
0.100	Min	.115	✓			
0.100	Min	.113	✓			
0.100	Min	.109	✓			
0.100	Min	.110	✓			

Measured by: RB

Date: 10/01/20

Audited by: WT

Date: 10/01/20 -

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL <u>✓</u>	<u>DS</u>

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NOTE: Date & initial all entries

8

7

6

5

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1

D

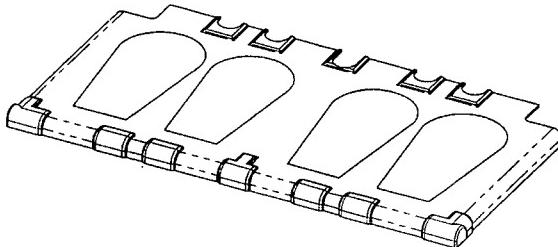
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C

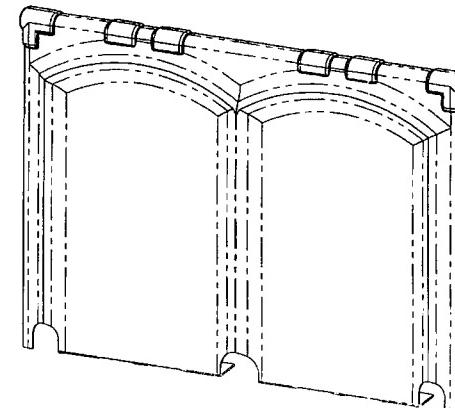
C

B

B



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

RELEASED
08-08-11/MJ

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	MJ	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MJ	DRAWING NO.	REV. B
MFG. APPR.	DW	D3774	SHEET 1 OF 3
APPROVED	MJ	TITLE	SCALE
DE APPR.	MJ	SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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A

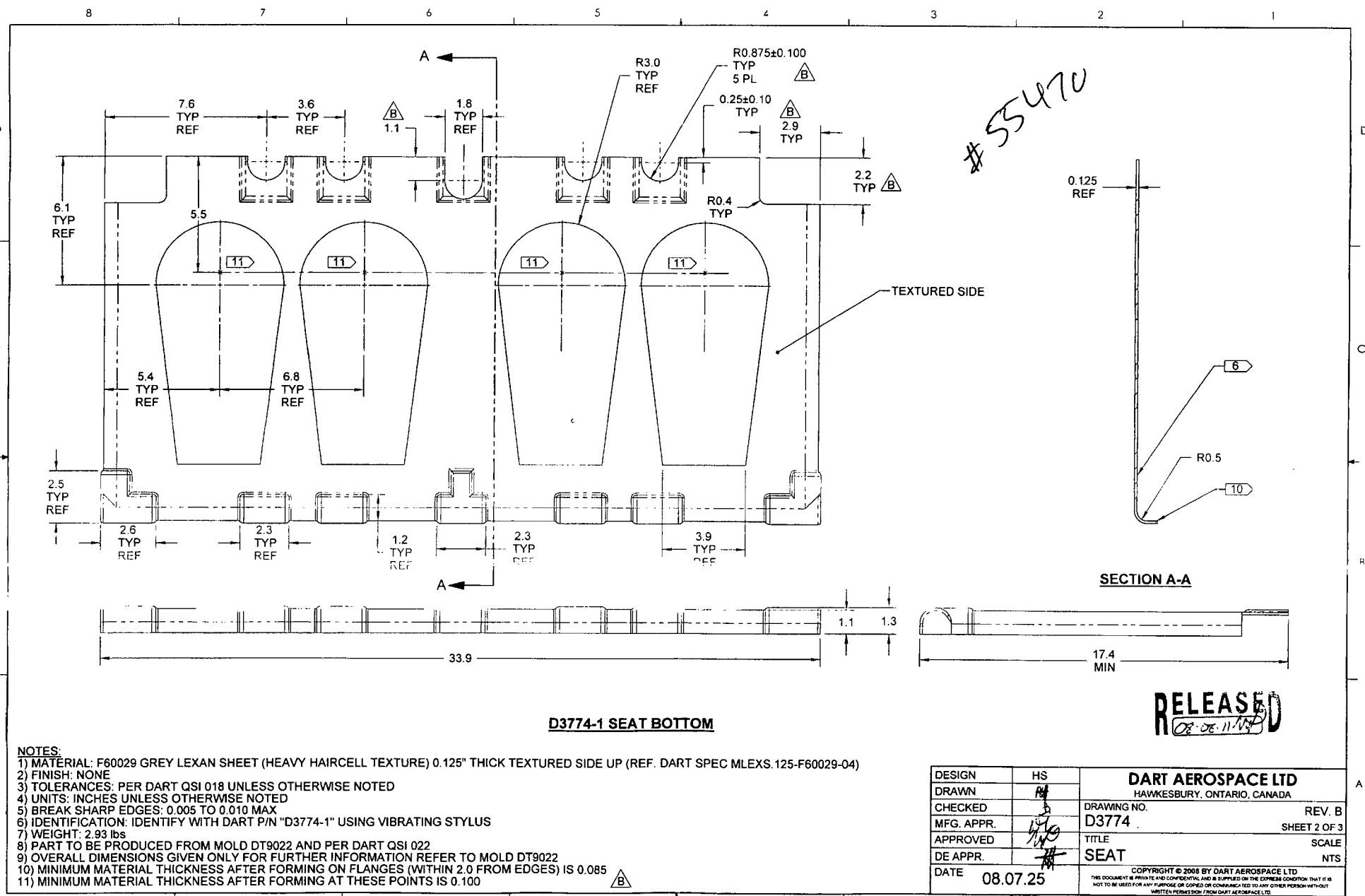
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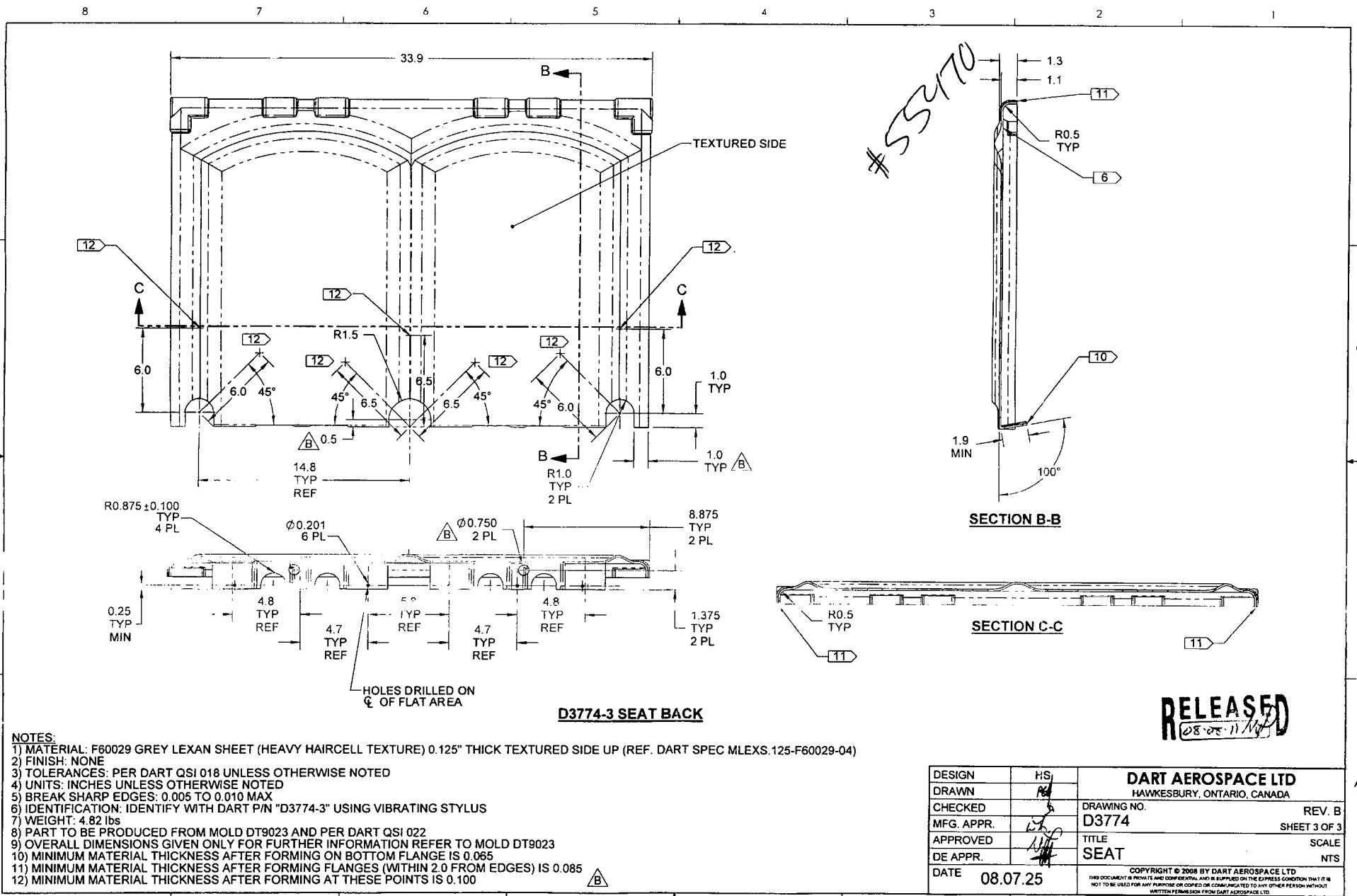


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